

93194

November-15-12 9:20:00 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 11/15/12 **Start Qty:** 8.00

8

Required Date: 12/07/12 **Req'd Qty:** 8.00

8

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: MCS Date: 12-11-16 Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
647.7700	N/C

110	Pick Kit	0.00
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110

Packaging	Memo	0.00
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Packaging

120 Weld per dwg A/R 4130 rod Batch: M 118875 0.00

120

Large Fab	Memo	0.00
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Large Fab

Memo	0.00
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1- ASSEMBLE AND WELD AS PER DWG

2- ON STRUT THREAD REMOVE CADE PLATE ONLY WHERE NEEDED
BEFORE WELDING

***IMPORTANT DIMENSION IS 23.75" ***

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November-15-12 9:20:00 AM

Item ID: 647.7702 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Strut Assembly
 Start Date: 11/15/12 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 12/07/12 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				(3)	13-03-07		DAS 09 8-08
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(8)	13-03-07		DAS 09 8-08
150 *150* SprayPaint Spray Painting	 Memo PRIOR TO PRIME MASK THREAD AND PRIME AS PER DWG PRIMER BATCH: <u>125452</u>	0.00 0.00				8	0	0	AP 13-6-5

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November-15-12 9:20:00 AM

Item ID: 647.7702 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Strut Assembly
 Start Date: 11/15/12 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 12/07/12 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC14- Inspect Spray Paint Memo	0.00 0.00		DAS 16 13/6/10		6.9			
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>ST139E</u> Memo ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***	0.00 0.00				8x	11.10	13-06-10	SP
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00					13/6/11		ME 13-6-10

Picklist Print

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Work Order ID: 93194

Parent Item: 647.7702

Parent Item Name: Strut Assembly

Start Date: 11/15/12

Required Date: 12/07/12

Start Qty: 8.00

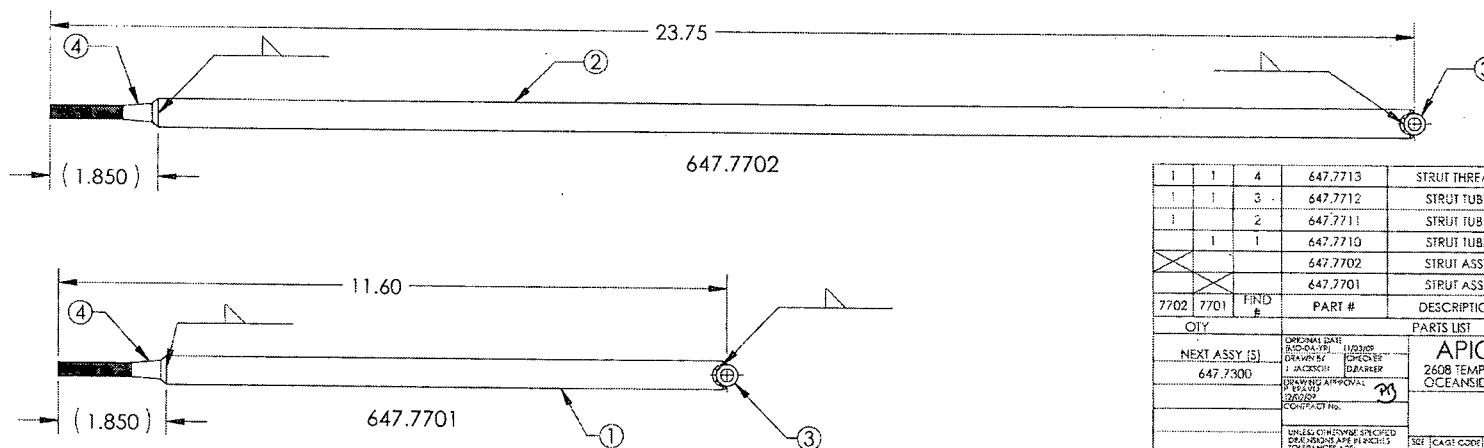
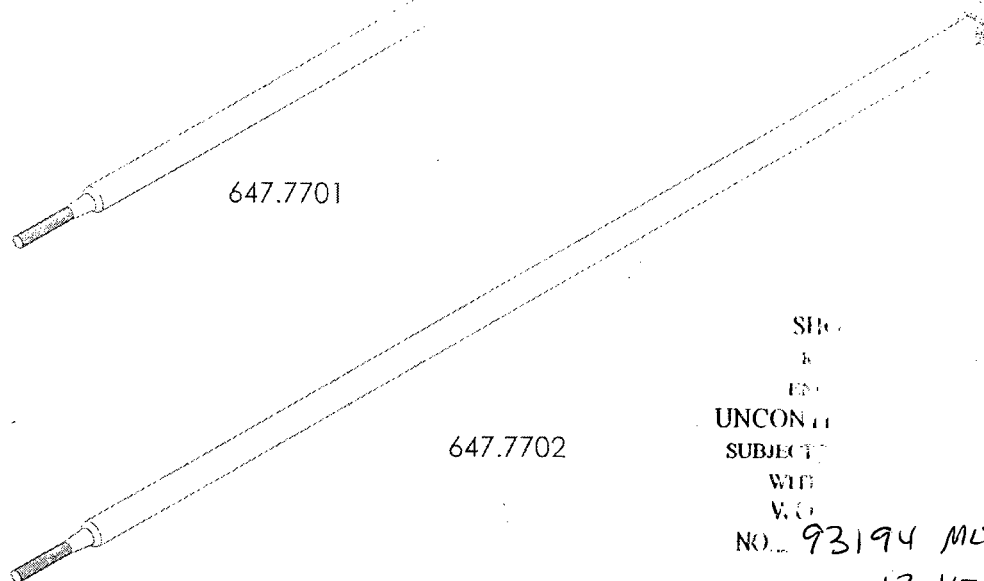
Required Qty: 8.00

Comments: IPP REV:A 12.11.01 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.7711 Strut Tube		Manufactured	No			110	Each	0.0000	1	8			
			93267x5		94115x3								
647.7712 Strut Tube		Manufactured	No			110	Each	0.0000	1	8			
			93203x5		94061x3								
647.7713 Strut Thread		Manufactured	No			110	Each	0.0000	1	8			
			93245x7		94100x1								

NOTES:

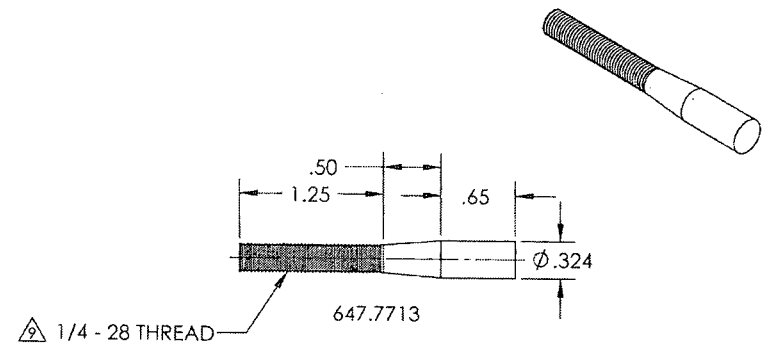
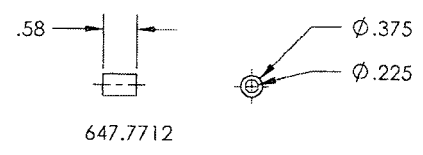
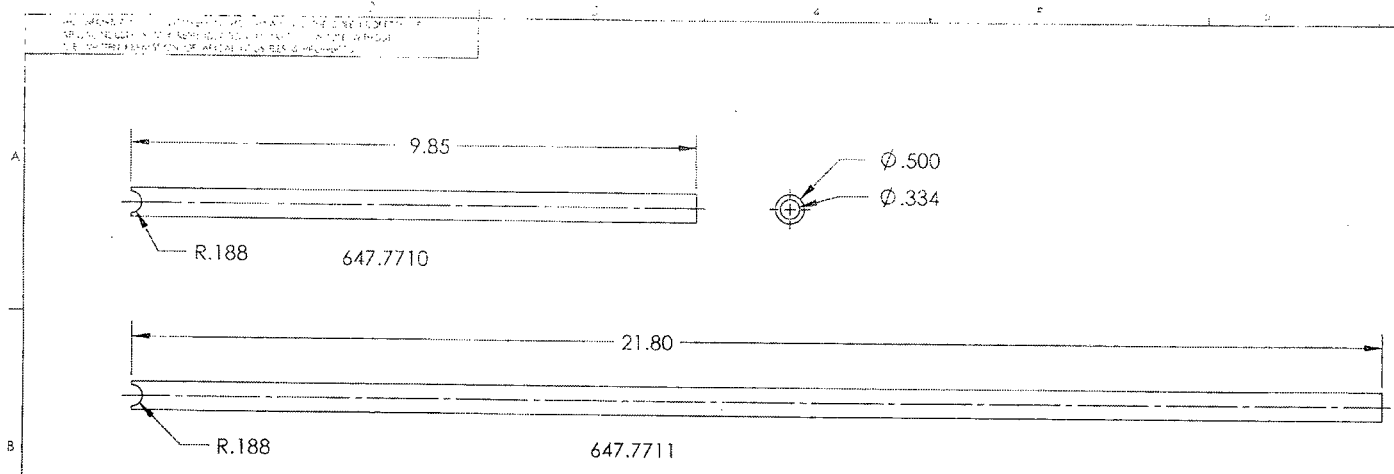
1. MATERIAL: 4130 STEEL PER AMS-I-6736, .50" OD, .083" WALL THK.
2. MATERIAL: 4130 STEEL PER AMS-I-6736, .375" OD, .075" WALL THK.
3. MATERIAL: 4130 STEEL PER AMS-T-6736, .324" OD.
4. FINISH: PRIME IAW MIL-P-2337J TYPE I CLASS N: 1-2 MIL MAX
5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MPP-120.
7. WELD IAW MIL-STD-2219, TIG WELD WITH FILLER ROD
8. FINISH: CAD PLATE IAW MIL-C-5541 CLASS 1A
9. MASK THREAD PRIOR TO FINISH



1	1	4	647.7713	STRUT THREAD	△	△
1	1	3	647.7712	STRUT TUBE	△	
1	1	2	647.7711	STRUT TUBE	△	
	1	1	647.7710	STRUT TUBE	△	
			647.7702	STRUT ASSY		△ △
			647.7701	STRUT ASSY		△ △
7702	7701	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
QTY				PARTS LIST		
NEXT ASSY (S)				APICAL INDUSTRIES		
647.7300				2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300		
				STRUT ASSY		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE PER MIL-STD-20 3 PLACE DECIMALS ±.01 1 ANGLES ±.5°				SIZE SCALE NONE	CASE CODE 07M16	DWG. NO. 647.7700
				SHEET 1 OF 2		

SUB
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FOR
UNCON
SUBJECT
WITH
V.O.
NO. 93194 MLJ
12-11-16

93194



ORIGINAL DATE BOOKING NO. 118209	APICAL INDUSTRIES		
DRAWN BY J. JACKSON	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300		
CHECKED BY J. JACKSON	STRUT ASSY		
DRAWING APPROVAL P. PRAVO			
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE FRACTIONS DECIMALS .01 ANGLES .5°	SHEET B	DATE 07/11/16	REV. N/C
	SCALE: NONE		SHEET 2 OF 2